

Date: Wednesday, 30/01/2008 2:24:02 PM
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : CYCLIC STICK
Job Number : 37120 - \ Part Number : D3630041
Estimate Number : 13108 Drawing Number : D3630 REV A
P.O. Number : Project Number : N/A
This Issue : 30/01/2008 S.O. No. : Drawing Revision : A
Prsht Rev. : NC Material :
First Issue : / / Type : SMALL / MED FAB Due Date : 06/02/2008 Qty: 3.5 Um: Each
Previous Run :
Written By :
Checked & Approved By :
Comment : Est Rev A 07-12-19 new issue ECN960 DD

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

M304TR1125W065

304 RD Tube 1.125 x .065w



Comment: Qty.: 2.4497 f(s)/Unit Total : 12.2483 f(s)

Material: 304/316 SS Seamless Tubing 1.125" OD x 0.065" wall(M304TR1125W065)

Batch: M1071498 M108225

FF 08-03-13

2.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

M08106/09

D3630

1-Cut to length as per Dwg D2536

2-Deburr

3-form D3630-5 as per dwg D3630

FF 08-06-18

FF 08-03-13

3.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08106/10 (18)

4.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1- Weld as per dwg D3630 and QSI004

2- Grind weld flush

R 08-06-13 (16)

5.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

D 08-06-13 (16)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3630-041 PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 09/01/19
 QA: N/C Closed: _____ Date: _____

WORK ORDER NON-CONFORMANCE (NCR)								
NCR: <u>37120-1</u>								
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
05/03/19	2	8 pieces were Scrap didn't have good radius, 3 pieces were try out	<i>[Signature]</i> 05/03/19	Scrap & destroy	FF 05/03/19	<i>[Signature]</i> 05/03/19	<i>[Signature]</i> 05/03/19	<i>[Signature]</i> 05/03/19
08/06/09	2	3PCS were damaged, Tool on bender was changed incorrectly installed we fixed it	<i>[Signature]</i> 08/06/09	Scrap and replaced	FF 08/06/09	<i>[Signature]</i> 08/06/09	<i>[Signature]</i> 08/06/09	<i>[Signature]</i> 08/06/09
08/06/09	2	1 over bend human error	<i>[Signature]</i> 08/06/09	Scrap and destroyed Not replaced	FF 08/06/09	<i>[Signature]</i> 08/06/09	<i>[Signature]</i> 08/06/09	<i>[Signature]</i> 08/06/09

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CYCLIC STICK

Job Number: 37120

Part Number: D3630041

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/06/19 (+6)

7.0

MILLING CONV.

CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

1-Drill holes as per dwg D3630
2- deburr

JL 08/07/14 (5)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/07/14 (5)

9.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- remove all scratches

FF 08-07-15 (5)

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/07/15 (5)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker, then Stock
Location: 57366

08/07/15 (5)

12.0

QC21

FINAL INSPECTION/W/O RELEASE



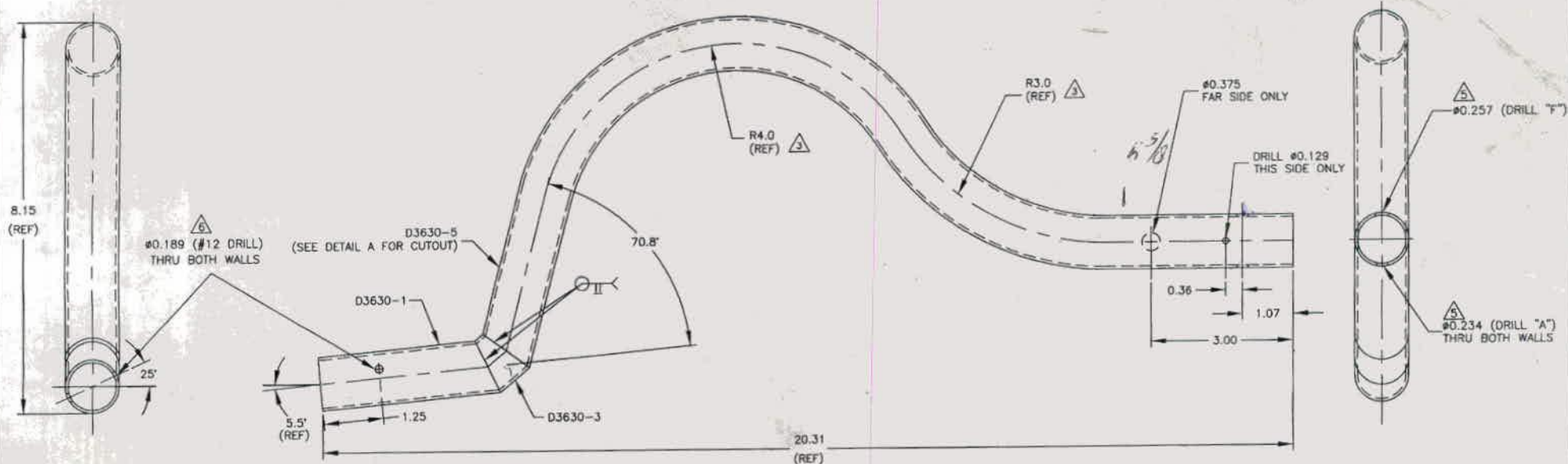
Comment: FINAL INSPECTION/W/O RELEASE

08/07/16

Job Completion



MF 08-07-16



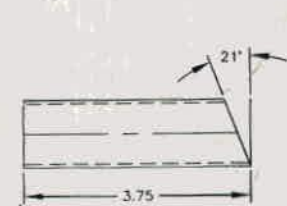
D3630-041 CYCLIC STICK
(REPLACES GENEVA P/N G10202)

NOTES:

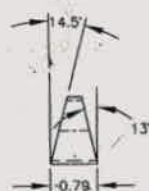
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SEAMLESS ROUND TUBING 1.125" OD X 0.065" WALL (REF. DART SPEC M304TR1.125W.065)
- 2) FINISH: NONE
- 3) REFER TO TEMPLATE DT8940
- 4) WELD PER DART QSI 004
- 5) DRILL #0.234 THRU BOTH WALLS THEN DRILL #0.257 THRU ONE WALL AS SHOWN
- 6) DRILL #0.189 THRU BOTH WALLS AT 25° OFF HORIZONTAL AXIS AS SHOWN
- 7) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 8) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 9) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 10) IDENTIFY WITH DART P/N "D3630-041" USING FINE POINT PERMANENT INK MARKER

PARTS LIST

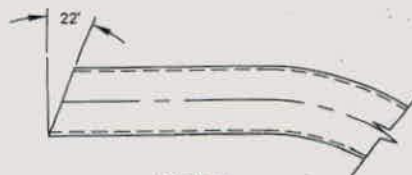
QTY	PART NUMBER	DESCRIPTION
1	D3630-041	CYCLIC STICK
1	D3630-1	TUBE
1	D3630-3	TUBE
1	D3630-5	TUBE



D3630-1
(REPLACES GENEVA P/N G10202-1)



D3630-3
(REPLACES GENEVA P/N G10202-2)



D3630-5
(REPLACES GENEVA P/N G10202-3)

DETAIL A: CUTOUT

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A	07.05.11	NEW ISSUE: REPLACES G10202
DESIGN C-LB	DRAWN BY JCL	DART DART AEROSPACE USA, INC. PORT HADLOCK, MA
CHECKED J	APPROVED H	DRAWING NO. D3630
DATE 07.05.11	TITLE CYCLIC STICK	REV. A SHEET-1 OF 1 SCALE 1:2

RELEASED
67-11-29

21
1
2